

Date: Monday, 8/13/2007 3:47:21 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET, GAS SPRING
Job Number	: 33883		
Estimate Number	: 10179		
P.O. Number	: <i>N/A</i>	Part Number	: D2144
This Issue	: 8/13/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2144 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: D
Previous Run	: 31782	Material	: <i>N/A</i>
Written By	: <i>JLM / 07-08-13</i>	Due Date	: 8/20/2007
Checked & Approved By	:	Qty:	50 Um: Each
Comment	: Est: D 04.05.06 Reformat KJ/RF Est Rev:E Now on Waterjet 06-10-15 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0945 sf(s)/Unit Total : 4.7250 sf(s)

304/316 .063 Sheet 16GA

Batch: *MCS 1308**IB 07-08-14*2.0 WATER JET *105136* FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2144

Dwg Rev: *D*Prog Rev: *D**IB 07-08-14**(S2)*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*IB 07-08-14*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*IB 07-08-14**counted**X52*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary *and pass open holes to finished size ml 07/08/23**X51*

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Part Number: D2144

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: D

SB 07/08/28

(S)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/28 counter (XSL)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004
2- Grind flush

104/09/17 (S)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 07-09-17 (S)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/17 counter (XSL)

11.0 POWDER COATING POWDER COATING



M 105068



(SIX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-R 07/09/18

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Er 07/09/18 (S)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5210

Er 07/09/18 (SIX)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

Dates 1/19

Job Completion



h 07-09-19

DART AEROSPACE LTD		Work Order:	
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.381	X			
3.022	+/-0.010	3.022	X			
2.468	+/-0.010	2.468	X			
1.913	+/-0.010	1.913	X			
1.555	+/-0.010	1.555	X			
4.126	+/-0.010	4.129	X			
3.465	+/-0.010	3.465	X			
0.340	+/-0.010	0.340	X			
0.625	+/-0.010	0.625	X			
1.000	+/-0.010	1.000	X			
1.083	+/-0.010	1.083	X			
1.660	+/-0.010	1.660	X			
2.312	+/-0.010	2.313	X			
2.844	+/-0.010	2.844	X			
3.294	+/-0.010	3.294	X			
Ø0.257	+0.006/-0.001	0.256	X			
Ø0.171	+0.005/-0.001	0.171	X			
Ø0.320	+0.006/-0.001	0.320	X			
0.354	+/-0.010	0.354	X			
0.063	+/-0.010	0.060	X			

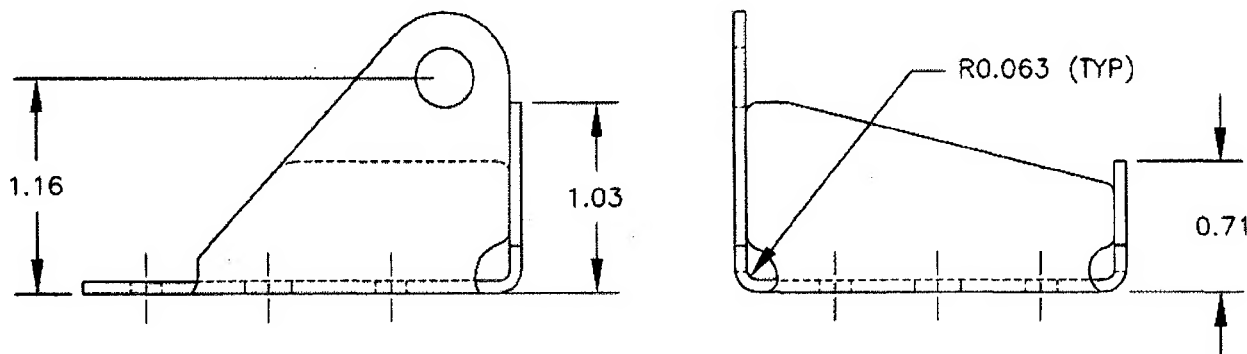
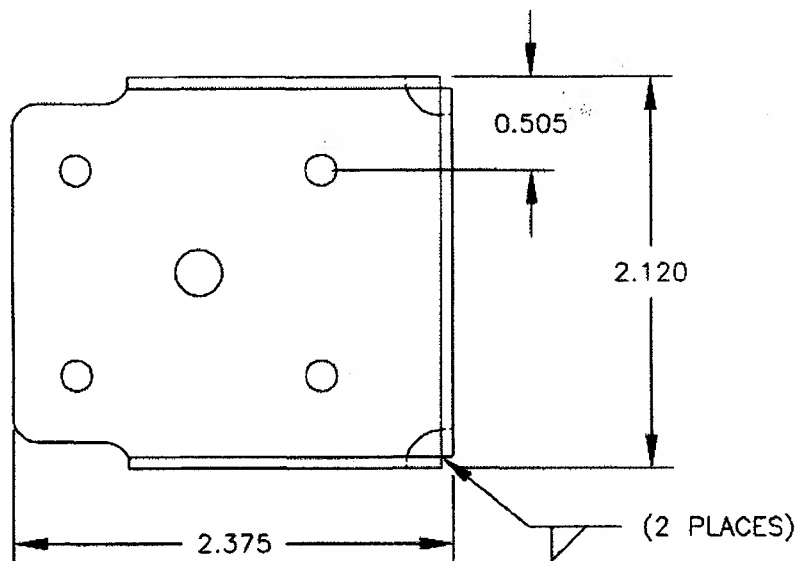
Measured by: IB	Audited by: ER	Prototype Approval:	N/A
Date: 07-08-14	Date: 07/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	



RELEASED
98.10.15 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
BW	KE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
MA	KE	D2144	
DATE	TITLE	SCALE	
98.10.08	HINGE BRACKET	1:1	
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	

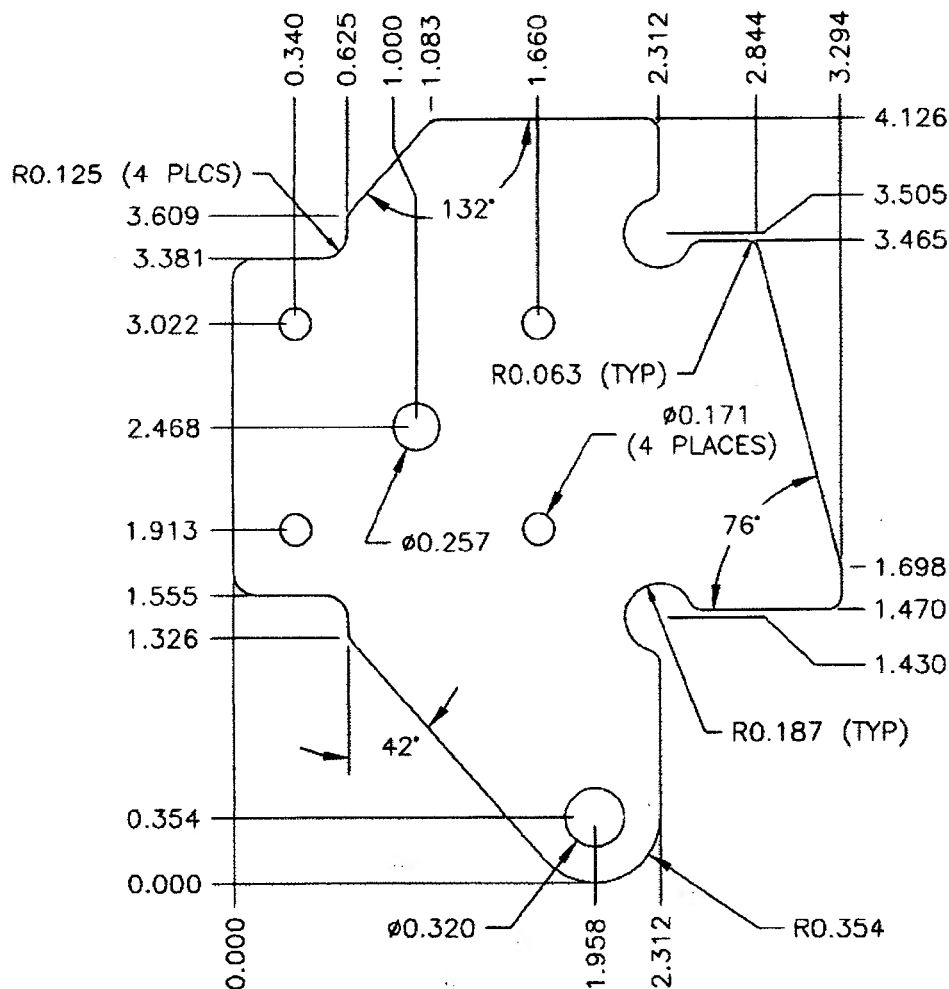


FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DWH	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1

RELEASED
98.10.15 KB



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES